

Date: Tuesday, 4/24/2007 3:14:47 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 32032A		
Estimate Number	: 10375		
P.O. Number	: <i>N/A</i>	Part Number	: D30651
This Issue	: 4/24/2007	Drawing Number	: D3065 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: B
Previous Run	: 31794A	Material	: <i>N/A</i>
	Type : SMALL /MED FAB	Due Date	: 5/20/2007
Written By	:	Qty:	60 Um: Each
Checked & Approved By	:		
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF		
	: Est:D 06.04.25 Water jet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.1300 sf(s)/Unit Total : 7.7994 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: *M103321**MM 07 05 24**(60)*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3065

Dwg Rev: *B*Prog Rev: *B**MM 07 05 24**(60)*

2-Debur as required

*SAN 07/06/06**60*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*MM 07 05 24**(60)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*MM 07 05 24**(60)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Debur if necessary.

*SAN 07/06/06**60*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 4 Date: 06/12/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:14:47 PM  
User: Kim Johnston

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 32032A

Part Number: D30651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3065

SB 07/07/17 (60)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/07/18 (460) Cont'd

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SB 07-07-18 (60)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB 07/07/19 (60)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 07/07/19 (60)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.19 (60)

Job Completion



U 07.07.19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>32032A</b>
<b>Description:</b> Step Spacer		<b>Part Number:</b>	<b>D3065-1</b>
<b>Inspection Dwg:</b> D3065 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	0.251	✓		vern	
2.093	+/-0.010	2.099	✓		vern	
3.936	+/-0.010	3.938	✓		vern	
4.186	+/-0.010	4.194	✓		vern	
0.587	+/-0.010	0.585	✓		vern	
Ø0.128	+0.005/-0.001	0.131	✓		vern	
R0.125	+/-0.010	R0.125	✓		Radius Gauge	
3.465	+/-0.010	3.465	✓		vern	
Ø1.250	+0.012/-0.001	1.252	✓		vern	
0.368	+/-0.010	0.365	✓		Height Gauge	
0.871 (Pitch)	+/-0.005	0.871	✓		vern	
0.040	+/-0.010	0.039	✓		vern	

<b>Measured by:</b>	<i>md. md</i>
<b>Date:</b>	07 05 24

<b>Audited by:</b>	<i>[Signature]</i>
<b>Date:</b>	07 05 24

<b>Prototype Approval:</b>	<i>N/A</i>
<b>Date:</b>	

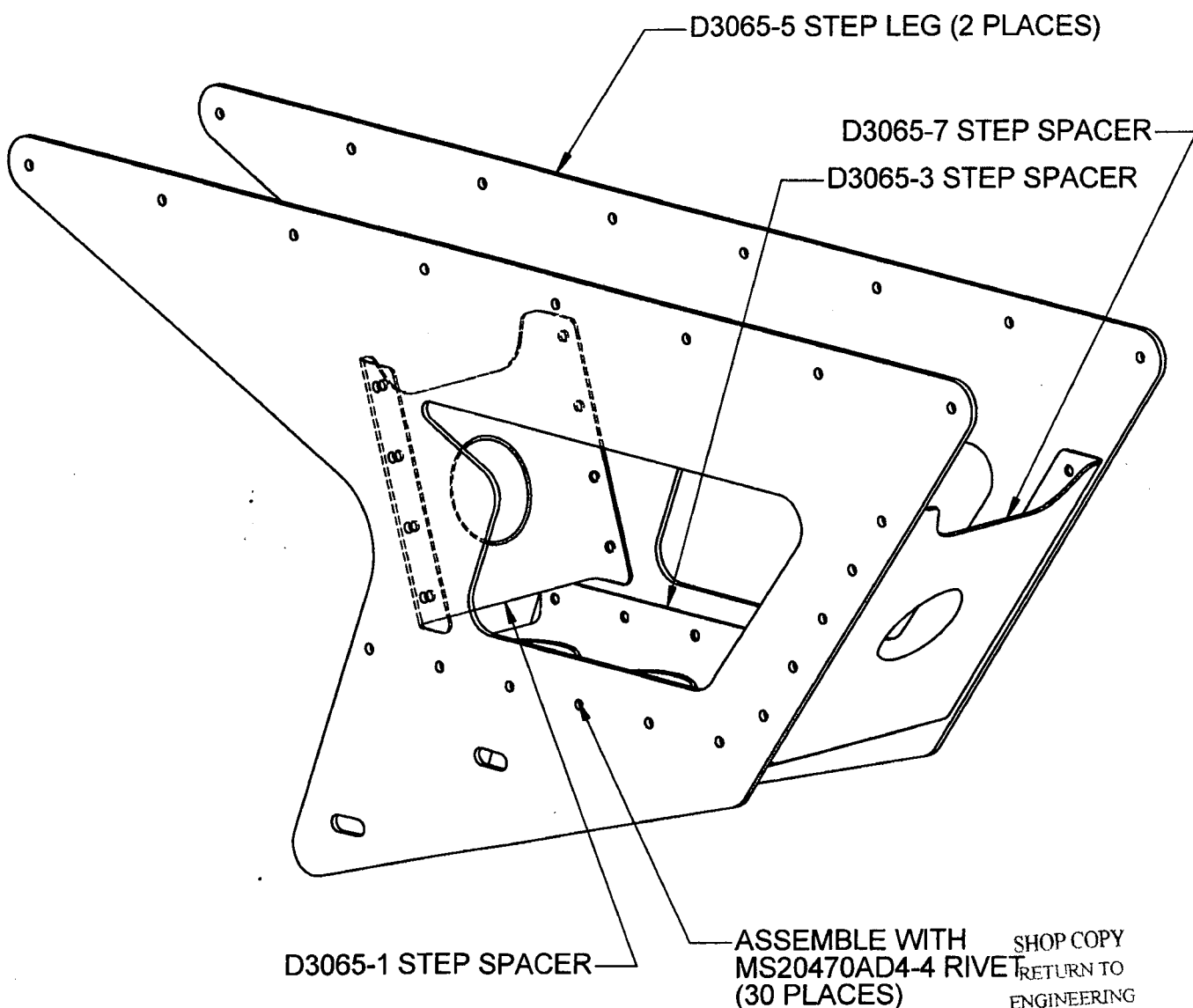
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue      P/O D3065-041	KJ/RF	
B	06.06.23	Dwg Rev. changed	KJ/JLM	
C	07.02.07	Dimension 0.040 added	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*

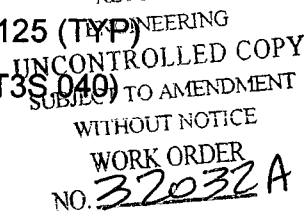
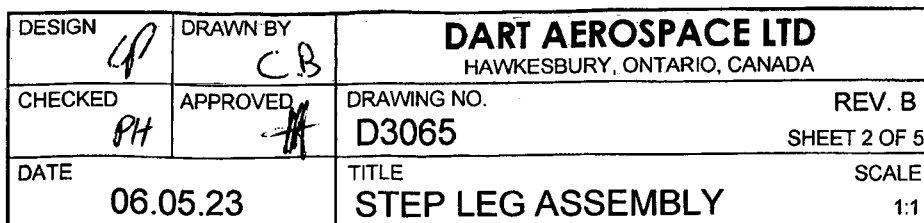


## D3065-041 STEP LEG ASSEMBLY

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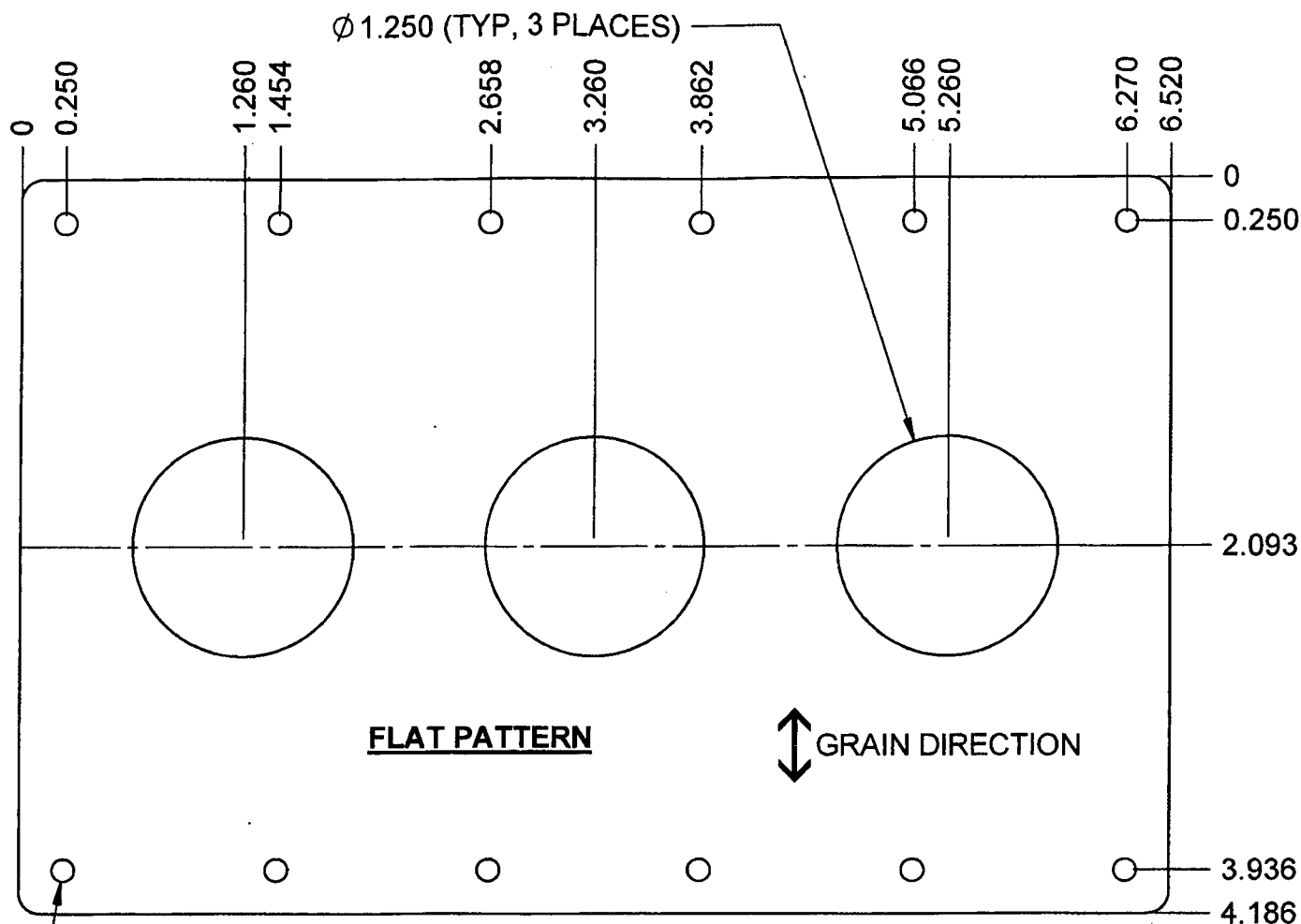
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

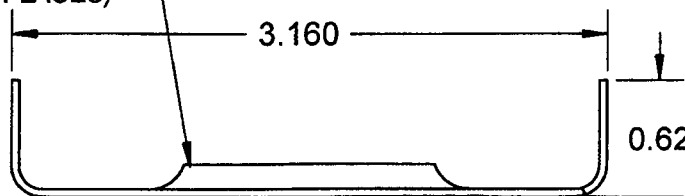


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06 06 20 *[Signature]*



**BEND DETAIL**

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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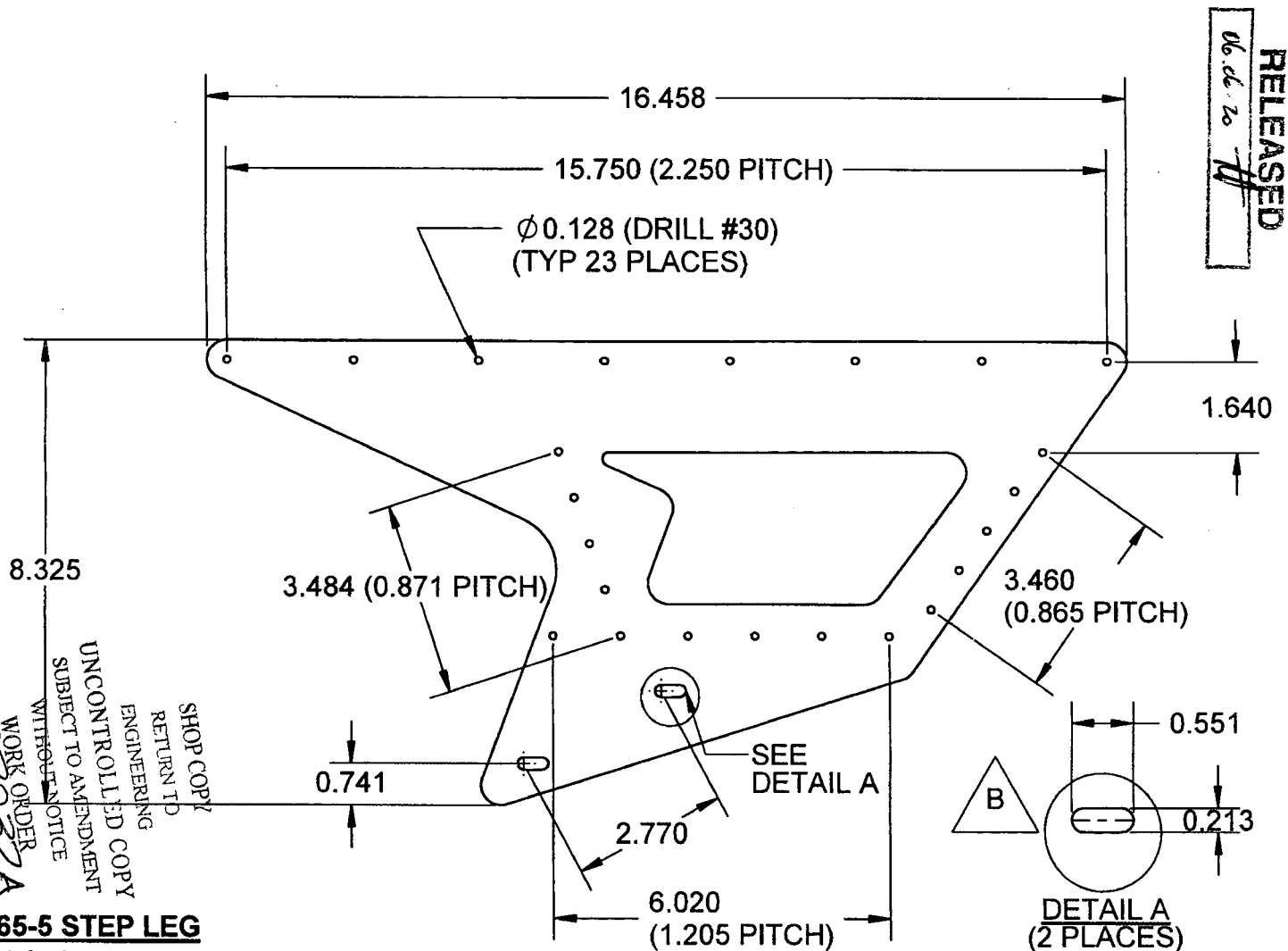
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**DART**

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				HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED		DRAWING NO.
				D3065
DATE	06.05.23	TITLE		REV. B
		STEP LEG ASSEMBLY		SHEET 4 OF 5
				SCALE
				1:3

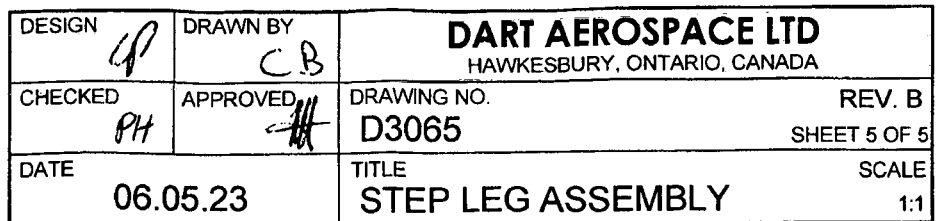


**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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24T3S 040)  
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NO. 32032A

## **D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC  
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
3) PART IS SYMMETRIC ABOUT CENTERLINE  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

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